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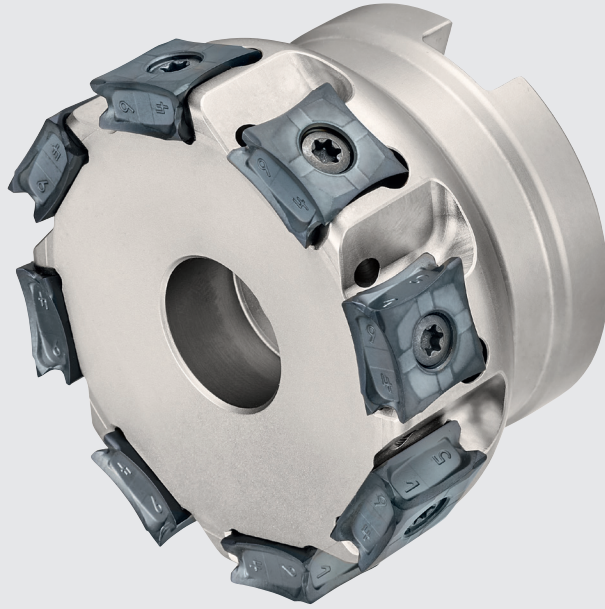
MultiEdge T90 PR08 and MultiFace P45 PR08
BUY 10 INSERTS PER POCKET
GET 1 BODY FREE of equal or lesser value

Order via your local distributor and reference **promo code: INDEX24**.
Promotion valid from 02-01-2024 thru 06-30-2024.



Process safety by tangential mounting of the inserts

Depth of cut up to 10 mm (0.394 in)



Cost savings through cycle time reduction

Press-to-size-insert with 8 effective cutting edges

The MultiEdge T90 PRO8 is as modular milling systems with tangential inserts. It is designed for roughing and semi finishing operations in steel and cast iron.

The program covers cutter bodies in the diameter range from 2 to 3 in and indexable inserts with cutting depths up to 10 mm (0.394 in) for the machining of steel (ISO P materials), cast iron (ISO K materials), and stainless steel (ISO M materials).

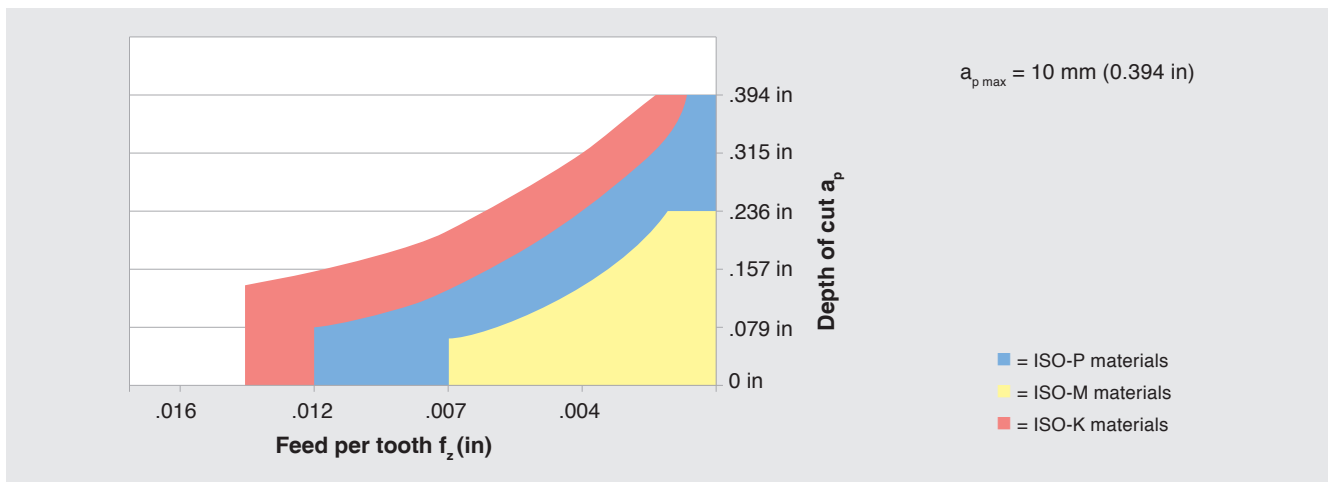
MultiEdge T90 PRO8



Cutting data recommendations

	Material	Hardness	Carbide grade
P	Plain carbon steel	<32 Rc <32 Rc <32 Rc	LCP40M LCPK30M
	Free cutting steel	<32 Rc <32 Rc	
	Plain carbon steel	<32 Rc	
	Heat-treatment steel, medium strength	<32 Rc	LCP40M LCPK30M
	Cast steel	<32 Rc	LCP40M LCPK30M
	Case hardening steel	<32 Rc	LCP40M LCPK30M
	Heat-treatment steel, high strength	30 - 44 Rc	LCP40M LCPK30M
	Nitriding steel, heat treated	30 - 44 Rc	LCP40M LCPK30M
	Tool steel	30 - 44 Rc	
M	Stainless steel, austenitic	<32 Rc	LCM45M
	Stainless steel, martensitic	<32 Rc	
K	Cast iron with flake graphite	<32 Rc	LCPK30M
	Alloyed cast iron	<32 Rc	LCPK30M
	Graphite cast iron	<32 Rc	LCPK30M
	Malleable cast iron	<32 Rc	LCPK30M

The cutting data indicated are starting values and must be adjusted to the prevailing conditions.

Recommended feed per tooth with $a_p = 0.66 \times d_1$



Recommended cutting speed v_c in in/min with $a_e = 0.66 \times d_1$	
v_c	
	656-722
	590-656
	459-525
	459-590
	394-525
	394-459
	 525 - 722  262 - 394
	656-787
	525-656
	459-590
	525-656

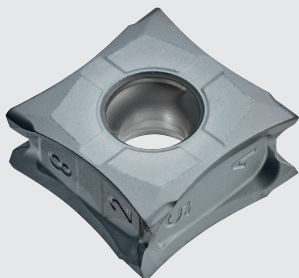


Wet machining, sufficient emulsion volume required

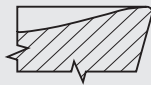


Dry machining, air-blast cooling is advantageous

XNMU



Chip-breakers:



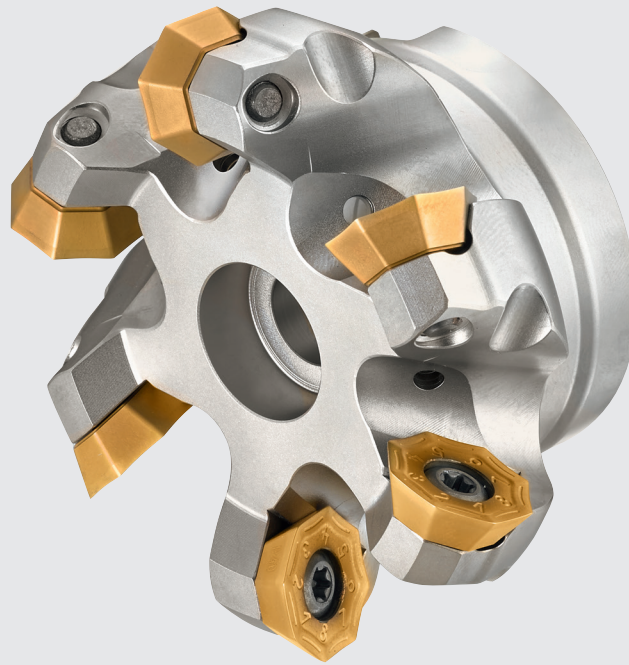
-ER

Features:

- Soft-cutting indexable insert geometry to reduce cutting forces
- Tangential insert with 8 cutting edges for high efficiency
- Depth of cut up to $a_{p \max} = 10 \text{ mm (0.394 in)}$

15° chipping angle for reduced machining forces

Depth of cut up to 4.0 mm (0.157 in)



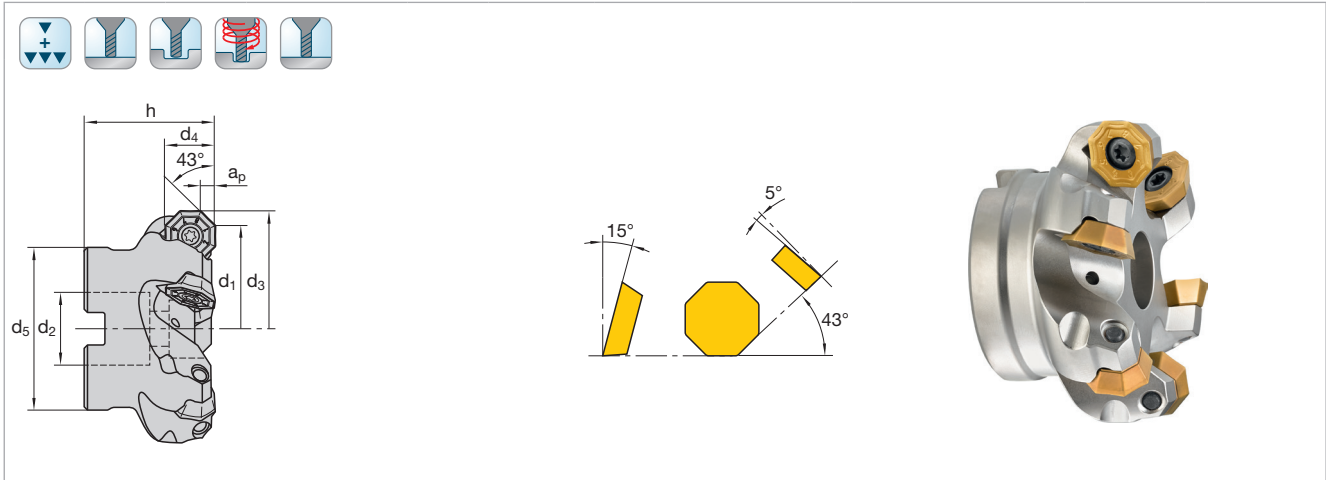
Cutting grades and coatings for a long tool life and high chipping volumes




Geometries for the machining of ISO-P, ISO-K, ISO-M and ISO-S

With the MultiFace P45 PRO8, LMT Fette is expanding its product range with a very soft cutting edge milling system for roughing and finishing different materials.

For the machining of different materials there are specially developed geometries and cutting materials.

In the diameter range from 2 to 3 inches, the standard program offers a normal as well as fine pitched version.



Cat.-No.							FMP45				
d_1	h	d_2	d_3	$a_p \text{ max}$	z	Ident No.	LMT-Code				
2	1.57	0.75	1.57	0.157	4	7273660	FMP45 O06.200AA-I	OEKT 06...	1045777	10488 T20	
2	1.57	0.75	1.57	0.157	5	7273666	FMP45 O06.200AA-IF				
3	1.97	1	2.36	0.157	6	7273662	FMP45 O06.300AB-I				
3	1.97	1	2.36	0.157	7	7273668	FMP45 O06.300AB-IF				

Cutting data recommendations starting page 10

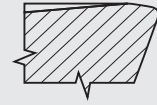


OEKT 0605 AE-SN

Features:

- Very stable geometry
- For challenging applications
- Negative chamfer with edge preparation

Chip-breaker



-SN

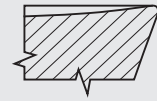


OEKT 0605 AEEN-BM

Features:

- Soft-cutting geometry
- For uncomplicated applications
- Additional 8° chipping angle with edge preparation

Chip-breaker



-BM

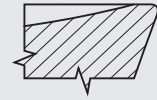


OEKT 0605 AESN-BMS

Features:

- Universal geometry
- For cross-section applications
- Additional 15° chipping angle with edge preparation

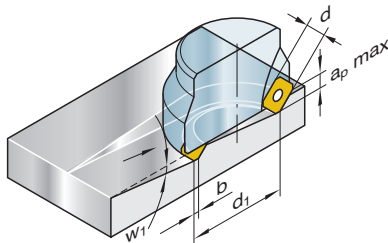
Chip-breaker



-BMS

Technical Hints

Ramping		
Bevel angle W_1 max. for plunge milling "ramping"		
Tool	FMP45	
Insert	OEKT 0605	
$a_{p \max}$ (in)	.157	
T_{\max} (in)	.118	
d_1 (in)	W_1 max Grad Degree	
2	5	
3	2.5	



T_{\max} : inner cutting depth

N = Number of cutting edges	ISO-Code	l	d	s	d ₁	r	Cutting materials Ident No.											Cat-No.					
							LCP40M	LCPM40M	LCPK30M	LCP25M	LCPK10M	LCM45M	LCMS35M	LCKP30M	LCKP10M	LCK20M	LCK10M		LCN10M	LWN10M	LCHP15M	LCH50M	
 N = 8	OEKT 0605 AESN	.236	.625	.219	.217	-	7212188		7212189			7212190									FMP45		
 N = 8	OEKT 0605 AEEN-BM	.236	.625	.219	.217	-	7212192					7212193										FMP45	
 N = 8	OEKT 0605 AESN-BMS	.236	.625	.219	.217	-	7212194					7212195											FMP45

■ = First choice
□ = Alternative

■	■	□																					P
□												■	■										M
											□												K
																							N
												■											S
																							H

MultiFace P45 PRO8
Cutting data recommendations

	Material	Hardness	Carbide Grade	
P	Plain carbon steel + free cutting steel	<32 Rc <32 Rc <32 Rc <32 Rc	LCP40M LCPK30M	
	Heat-treatment steel, medium strength	<32 Rc	LCP40M LCPK30M	
	Cast steel	<32 Rc	LCP40M	
	Case hardening steel	<32 Rc	LCP40M	
	Stainless steel, ferritic, martensitic	<32 Rc	LCP40M LCPK30M	
	Heat-treatment steel, high strength	30 - 44 Rc	LCP40M LCPK30M	
	Nitriding steel, heat treated	30 - 44 Rc <32 Rc	LCP40M LCPK30M	
	Tool steel	<35 Rc <36 Rc <35 Rc 30 - 36 Rc 30 - 44 Rc <30 Rc <32 Rc 30 - 44 Rc 35 - 42.5 Rc	LCP40M LCPK30M	
	M	Stainless steel, austenitic	<32 Rc	LCM45M LCMS35M
		Stainless steel, martensitic steel	<32 Rc	LCM45M LCMS35M
	K	Grey cast iron	<32 Rc	LCKP30M
		Alloyed grey cast iron	<32 Rc	LCKP30M
Nodular cast iron		<32 Rc	LCKP30M	
Malleable cast iron		<32 Rc	LCKP30M	
N	Aluminium alloys, short chipping	<32 Rc	LCN10M	
	Aluminium alloys, long chipping	<32 Rc	LWN10M	
	Copper alloys, short chipping	<32 Rc	LWN10M LCN10M	
	Copper alloys, long chipping	<32 Rc	LWN10M LCN10M	
	Thermoplastics	<32 Rc	LWN10M	
	Duroplastics	<32 Rc	LWN10M	
S	Titanium alloys, medium strength	<32 Rc	LCMS35M	
	Titanium alloys, high strength	27 - 44 Rc	LCMS35M	
	Nickel based alloys, medium strength	<32 Rc	LCMS35M	
	Heat resistant nickel based alloys, high strength	27 - 44 Rc	LCMS35M	

Roughing			Finishing		
v_c (in/min)	f_z (in/z)	a_p (in) (max .157 in)	v_c (in/min)	f_z (in/z)	a_p (in)
492-820 590-919	.0078-.0157 .0059-.0118	.1181-.1575	590-984 656-1050	.0031-.0078 .0031-.0059	.0079-.0787
492-820 590-919	.0078-.0157 .0059-.0118	.1181-.1575	328-820 427-919	.0031-.0059 .0031-.0039	.0079-.0787
492-820	.0078-.0157	.1181-.1575	590-984	.0031-.0078	.0079-.0787
328-656	.0078-.0157	.1181-.1575	590-984	.0031-.0059	.0079-.0787
328-656 427-722	.0078-.0157 .0059-.0118	.1181-.1575	492-820 590-984	.0031-.0059 .0031-.0039	.0079-.0787
328-656 427-722	.0078-.0157 .0059-.0118	.1181-.1575	492-820 590-984	.0031-.0059 .0031-.0039	.0079-.0787
328-656 427-722	.0078-.0157 .0059-.0118	.1181-.1575	492-820 590-984	.0031-.0059 .0031-.0039	.0079-.0787
328-656 427-722	.0078-.0157 .0059-.0118	.1181-.1575	492-820 590-984	.0031-.0059 .0031-.0039	.0079-.0787
328-656 427-722	.0078-.0157 .0059-.0118	.1181-.1575	492-820 590-984	.0031-.0059 .0031-.0039	.0079-.0787
262-394 525-722	.0059-.0098	.0394-.1181	262-394 525-787	.0020-.0059	.0079-.0393
197-328 525-722	.0078-.0157	.0394-.1181	197-328 525-787	.0020-.0059	.0079-.0393
328-787	.0039-.0138	.1181-.1575	656-853	.0039-.0078	.0079-.0787
328-590	.0039-.0138	.1181-.1575	525-656	.0039-.0078	.0079-.0787
328-525	.0039-.0138	.1181-.1575	459-590	.0039-.0078	.0079-.0787
328-656	.0039-.0138	.1181-.1575	525-722	.0039-.0078	.0079-.0787
1312	.0118-.0157	.1181-.1575	1312	.0039-.0078	.0079-.0787
1640-3281	.0118-.0157	.1181-.1575	1640-3281	.0039-.0078	.0079-.0787
492-984	.0118-.0157	.1181-.1575	656-1148	.0039-.0078	.0079-.0787
820-1640	.0118-.0157	.1181-.1575	984-1640	.0039-.0078	.0079-.0787
590-984 656-820	.0118-.0157 .0118-.0157	.1181-.1575 .1181-.1575	656-1312 656-820	.0039-.0078 .0039-.0078	.0079-.0787 .0079-.0787
131-262	.0020-.0059	.0394-.0984	131-262	.0020-.0039	.0079-.0393
65-197	.0020-.0059	.0197-.0787	98-197	.0020-.0039	.0079-.0393
98-262	.0020-.0059	.0394-.0984	131-262	.0020-.0039	.0079-.0393
98-262	.0020-.0059	.0394-.0984	131-262	.0020-.0039	.0079-.0393

